

Date: Monday, 7/9/2007 3:44:03 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SUPPORT
Job Number	33430A			
Estimate Number	10452			
P.O. Number	N/A		Part Number	D32781
This Issue	7/9/2007	S.O. No.	Drawing Number	D3278 REV. B
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	B
Previous Run	32657A		Material	N/A
Written By			Due Date	7/27/2007
Checked & Approved By	<i>JL 07.10</i>		Qty:	<i>40</i>
Comment	Est:A 04.04.19 New issue KJ/JLM		Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"  M105411 X 18 PCS
		Comment: Qty.: 0.2454 f(s)/Unit Total : 9.8154 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000X02.000) Batch: M104/87 X 17 PCS  M105817X5 <i>2000x1000x2550</i> <i>J.L 07/09/06</i>
2.0	SHEAR	SHEAR
		Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long <i>J.L 07/09/06</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Debur and Tumble. Identify as D3278-1 <i>8F 07/12/01</i> <i>42</i> <i>JMK 07/11</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>JMK 07/11</i>
5.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>J.L 07/12/02</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/10/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: SUPPORT	
Job Number: 33430A	Part Number: D32781	
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING 	HAND FINISHING RESOURCE #1  <i>(42)</i>
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		<i>JK 07-12-03</i>
7.0	POWDER COATING 	POWDER COATING  <i>M105914</i>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<i>JF 07-12-03 (42)</i>
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT		<i>MF 07-12-04 (42)</i>
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>GA</i>		<i>MF 07-12-04 (42)</i>
10.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>(42)</i>
Comment: FINAL INSPECTION/W/O RELEASE		<i>DA7/12/05</i>
Job Completion	 <i>u 8/12/04</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33430A
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø0.099	—			
0.359	+/-0.005	0.358	—			
0.609	+/-0.010	0.614	—			
0.250	+/-0.010	0.252	—			
1.480	+/-0.005	1.481	—			
R0.125	+/-0.010	R0.125	—			
0.119	+0.005/-0.004	0.120	—			
2.439	+/-0.010	2.441	—			
1.980	+/-0.010	1.981	—			
R0.13	+/-0.030	R0.130	—			
Ø0.257	+0.005/-0.000	Ø0.260	—			
R0.375	+/-0.010	R0.375	—			
0.875	+/-0.010	0.874	—			
0.500	+/-0.010	0.370	—			
R0.400	+/-0.010	R0.406	—			
R1.00	+/-0.030	R1.00	—			
1.720	+/-0.010	1.721	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.128	—			

Measured by:	John S.	Audited by:	B	Prototype Approval:	N/A
Date:	07/11/30	Date:	07/11/30	Date:	N/A

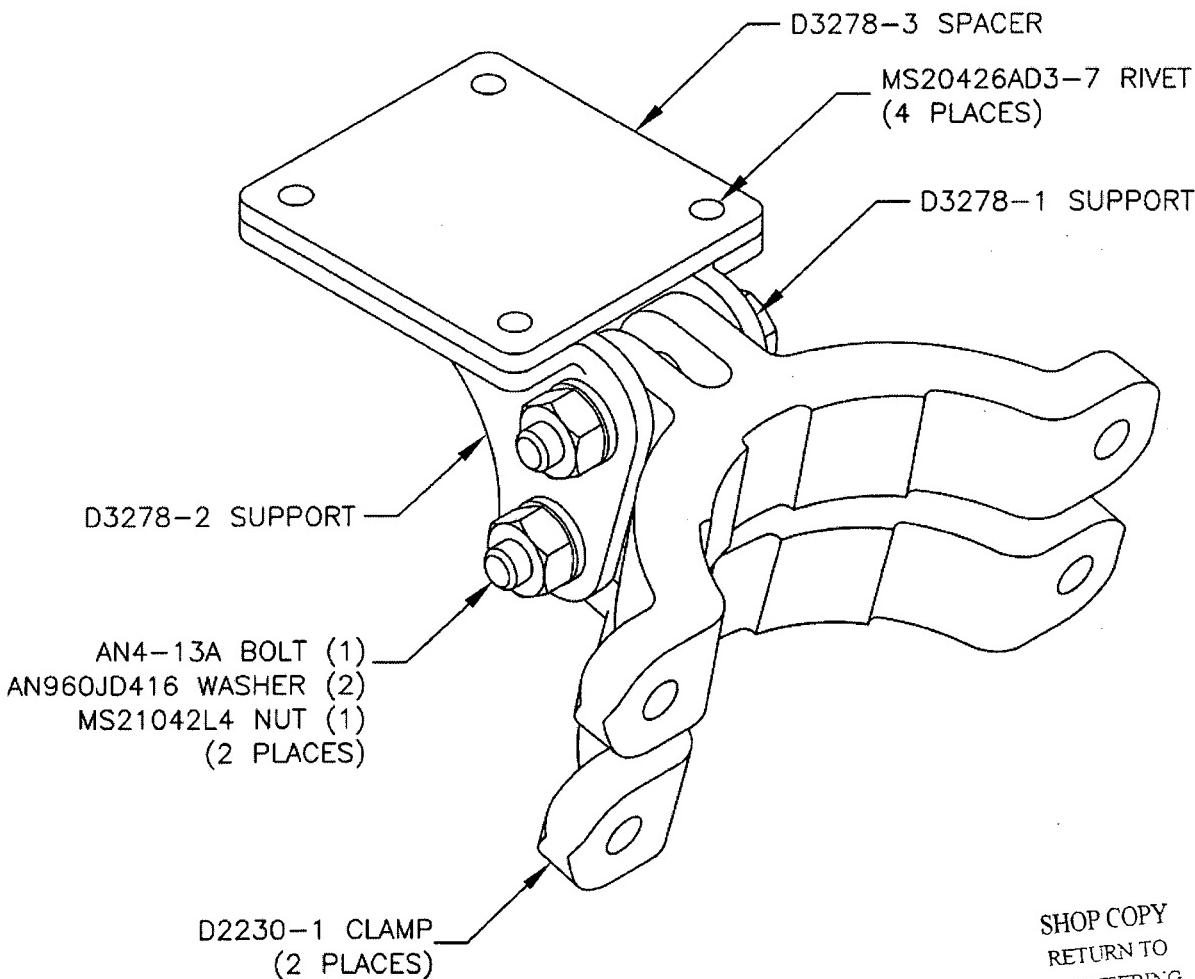
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	EZ

**DART**

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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

**RELEASED**  
05.04.04 - *[Signature]*

## D3278-041 SUPPORT ASSEMBLY



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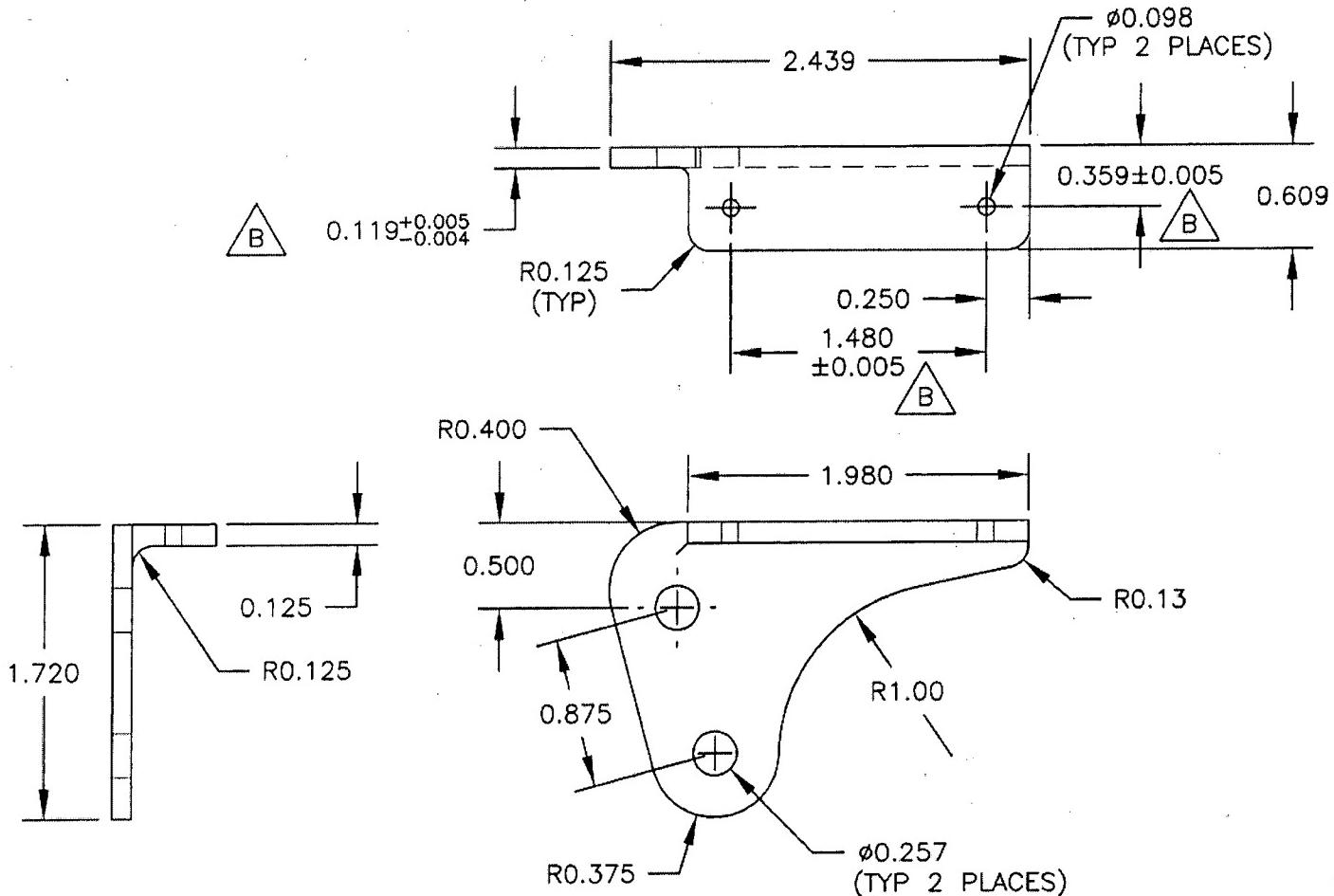
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 2 OF 3 SCALE 1:1

RELEASED

05.04.04

D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250F99P)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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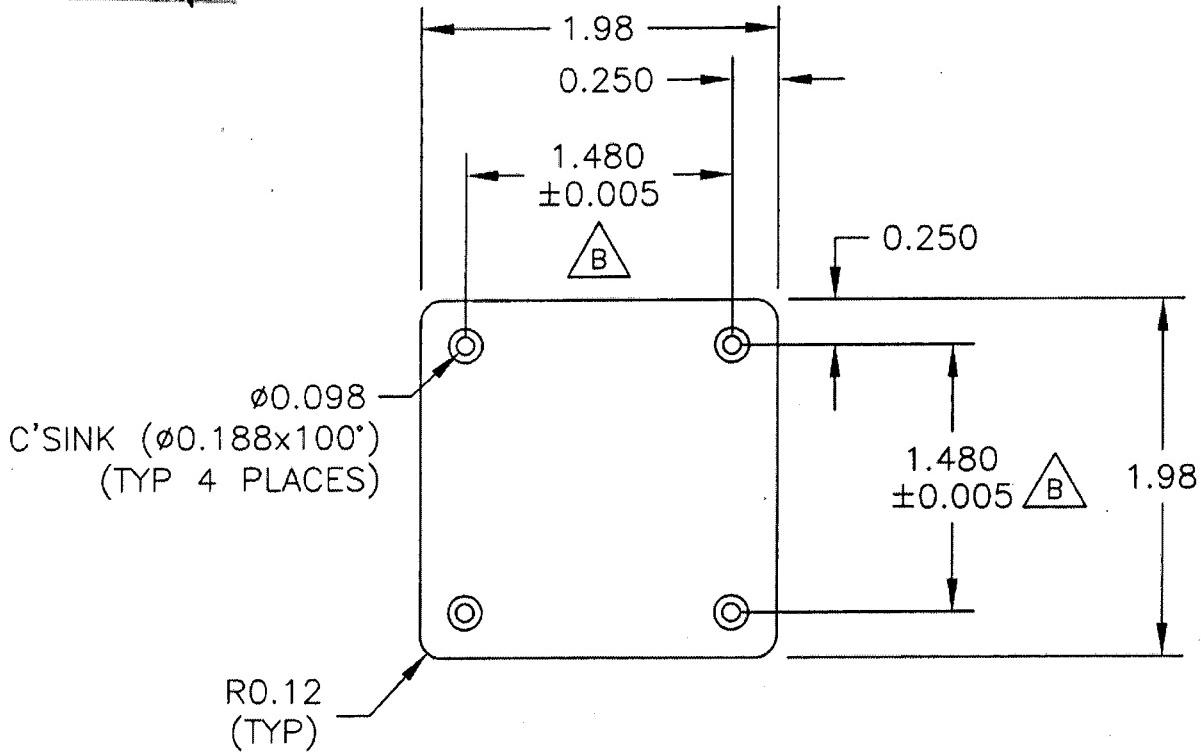
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DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 3 OF 3 SCALE 1:1

RELEASED

05.04.04 *[Signature]*



D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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